



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3910

Job Sheet 170479



Part No: 646.3910

Job Qty: 32 ea

Part Name: Shim



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 2/8/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV nc1 IPP REV:A 12.12.23 NEW ISSUE DD VERF:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	32 Ea		2/7/18	0.00	0.00	Start Up Waterjet		SC 18/02/03
110	Waterjet	32 pcs		2/8/18	0.01	0.77	Waterjet1		SC 18/02/03
120	QC	32 pcs		2/8/18	0.00	0.00	QC2 Waterjet-1		SC 18/02/03
130	QC	32 pcs		2/8/18	0.00	0.00	QC8-1		SC 18/02/03
140	Outsource	32 pcs		2/8/18			GRO002-VC		ATD 18/02/15
150	Packaging	32 pcs		2/8/18	0.00	0.00	Packaging2		max 18/02/15
160	QC	32 pcs		2/8/18	0.00	0.00	QC5		38
170	Packaging	32 pcs	33 pcs	2/8/18	0.00	0.00	Packaging3-1	CCK 106	FEB 16 2018
180	QC21-SA	32 Ea		2/8/18	0.00	0.00	QC21		FEB 16 2018

Part Op 110 - 1-Cut as per Dwg

Descriptions: 140 - Issue P/O: 038997 Cad Plating

170 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MC1095S.020	1	1	0	0
	M138 424	1,46			

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Shim	1.570Inches ± 0.005	1.575 1.565	1,571	
2	Shim	2.900Inches ± 0.005	2.905 2.895	2,901	
3	Shim	0.020Inches ± 0.005	0.025 0.015	0,020	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description Wc _____	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Packaging Supplier ☐ Engineering ☐ Quality ☐ Other ☐									
		Job No: 170479 Start up Operation 02/04/18		Change No: Operation: Revision: Original Serial #: S038811 PART NO: 646.3910		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval					
 S038811 											
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verificat ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verificat ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com <table style="width:100%;"> <tr> <td style="width:33%;"> Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%;"> BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>					Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐
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OTHER : _____											



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038997

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO038997

PO Date: 2/8/18

Due Date: 2/15/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
FEB 12 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	169930	RBW6405G02131-3G-5	Quarter Bell -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	2/15/18	4 pcs	0 pcs ✓ 4x	4 pcs	\$11.25/pcs	\$45.00 AT 18/02/15
2	170256	RBT18560-3	Ring -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	2/15/18	7 pcs	0 pcs	7 pcs	\$6.3158/pcs	\$44.21
3	170479	646.3910	Shim Issue P/O: _____ Cad Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	2/15/18	33 pcs	0 pcs ✓ 33x	33 pcs	\$4.16/pcs	\$137.28 AT 18/02/15
4	170481	646.3912	Shim Issue P/O: _____ Cat Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	2/15/18	22 pcs	0 pcs	22 pcs	\$4.16/pcs	\$91.52
5	170703	RBT18560-9	Cross Bar -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	2/15/18	6 pcs	0 pcs	6 pcs	\$6.3158/pcs	\$37.89
6	171015	RBW6405G02131-3G-5	Quarter Bell -Issue P/O to Groupe Altech:	Firmed	2/15/18	4 pcs	0 pcs ✓ 4x	4 pcs	\$11.25/pcs	\$45.00 AT 18/02/15

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2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Certificat de Conformité / Certificate of Compliance



Bon de Livraison / Packing Slip

006598 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax:.

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.
14-Feb-2018	Curtis Anderson		038997

#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	RBW6405G02131-3G-5 Rev.	QUARTER BELL 01-ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] SPÉC: ASTM B633 TYPE 1 SC2 ***	ZINC CH	4	4	0	0	0
3	646.3910 SHIM Rev.	646.3910 SHIM CAD PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM CH	33	33	0	0	0
6	RBW6405G02131-3G-5 Rev.	QUARTER BELL 01-ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] SPÉC: ASTM B633 TYPE 1 SC2 ***	ZINC CH	4	4	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.